

Work Order ID 106290

106290

Page 1

August-29-13 8:26:00 AM

Item ID: D4542-7 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Retainer, Inner
 Start Date: 8/28/13 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 8/28/13 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4542	D								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1- Cut as per dwg								
	Prog rev: <u>0</u>								
	Dwg rev: <u>0</u>								
	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

12 0 JMB-09-10

12 0 JMB-09-10

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106290

Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 DAS 27 9-89 13 9 10				12			
125 *125* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12	76	13-9-10	
127 *127* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00 13 9 11				12			

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Page 3

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST532</u>	0.00							
130									
Packaging	Memo	0.00				12X	28	13-09-11	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

13/9/13 *[Signature]*
 13-09-11

Picklist Print

August-29-13 8:26:00 AM

Page 1

Work Order ID: 106290
Parent Item: D4542-7
Parent Item Name: Retainer, Inner

Start Date: 8/28/13
Start Qty: 12.00
Required Date: 8/28/13
Required Qty: 12.00

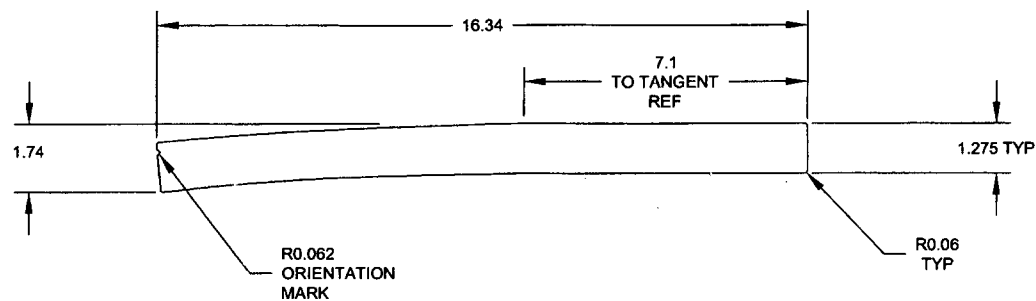
Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg
reva DD verf:EC IPP REV:C 12.05.08 as per dwg revB DD verf:EC IPP
REV:D 12.08.08 AS PER DWG REV.C DD VERF:EC IPP REV:E 13.04.23 as per dwg
revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No				sf	1,096.1660		2.4884208 2.5		Jan 13-09-10	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	1096.166	
123135	8.5	
123137	10	
123293	10	
123483	256.6	
m125822	67.3	
m126115	74.866	
m126147	305.15	
m126309	363.75	

126309

GRAIN DIRECTION



D4542-7 RETAINER, INNER
(TOP)



106290

RELEASED
2013-04-22

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs
- 8) PROFILE PER DRAWING FILE "D4542-7-REVD.DXF"

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESSBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4542	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER, INNER	NTS
DATE	13.02.04	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	